

Date: Wednesday, 5/31/2006 7:36:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 27288	
Estimate Number : 11375	
P.O. Number : N/A	Part Number : D33871
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27104	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 6/15/2006
Checked & Approved By : <i>J.F. 06.05.31</i>	Qty: 10 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total: 15.6849 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: *M101092*

J.F. 06/06/06 (10)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

J.F. 06/06/06 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387
 Identify as D3387-1
 Tumble and Deburr NO sharp edges

J.F. 06/06/07 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387

J.F. 06/06/07 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/06/07 10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/06/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PAT*

06/06/08 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/06/08 (10)


Job Completion



u 06.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27288
Description: Arm		Part Number:	D3387-1
Inspection Dwg: D3387	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R0.125	✓			
0.125	+0.020/-0.000	0.135	✓			
Ø0.375 x100°	+/-0.010					
R0.032	+/-0.010	R0.032	✓			
0.500	+/-0.010	0.494	✓			
0.500	+/-0.010	0.502	✓			
7.577	+/-0.010	7.574	✓			
R0.125	+/-0.010	R0.125	✓			
Ø0.507	+0.000/-0.001	Ø0.5066	✓			
0.250	+/-0.010	0.247	✓			
1.347	+/-0.010	1.347	✓			
2.000	+/-0.010	2.002	✓			
1.000	+/-0.010	1.001	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
R0.300	+/-0.010	R0.300	✓			
2.033	+/-0.010	2.032	✓			
0.250	+/-0.010					
0.232	+/-0.010					
1.700	+/-0.010	1.702	✓			
0.188	±.010	0.190	✓			
0.300	±.010	0.301	✓			

Measured by:	<i>mf</i>	Audited by:	<i>J.L</i>	Prototype Approval:	N/A
Date:	06/06/06	Date:	06/06/06	Date:	N/A

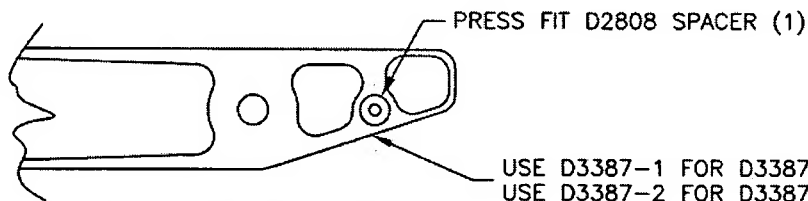
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>

DART

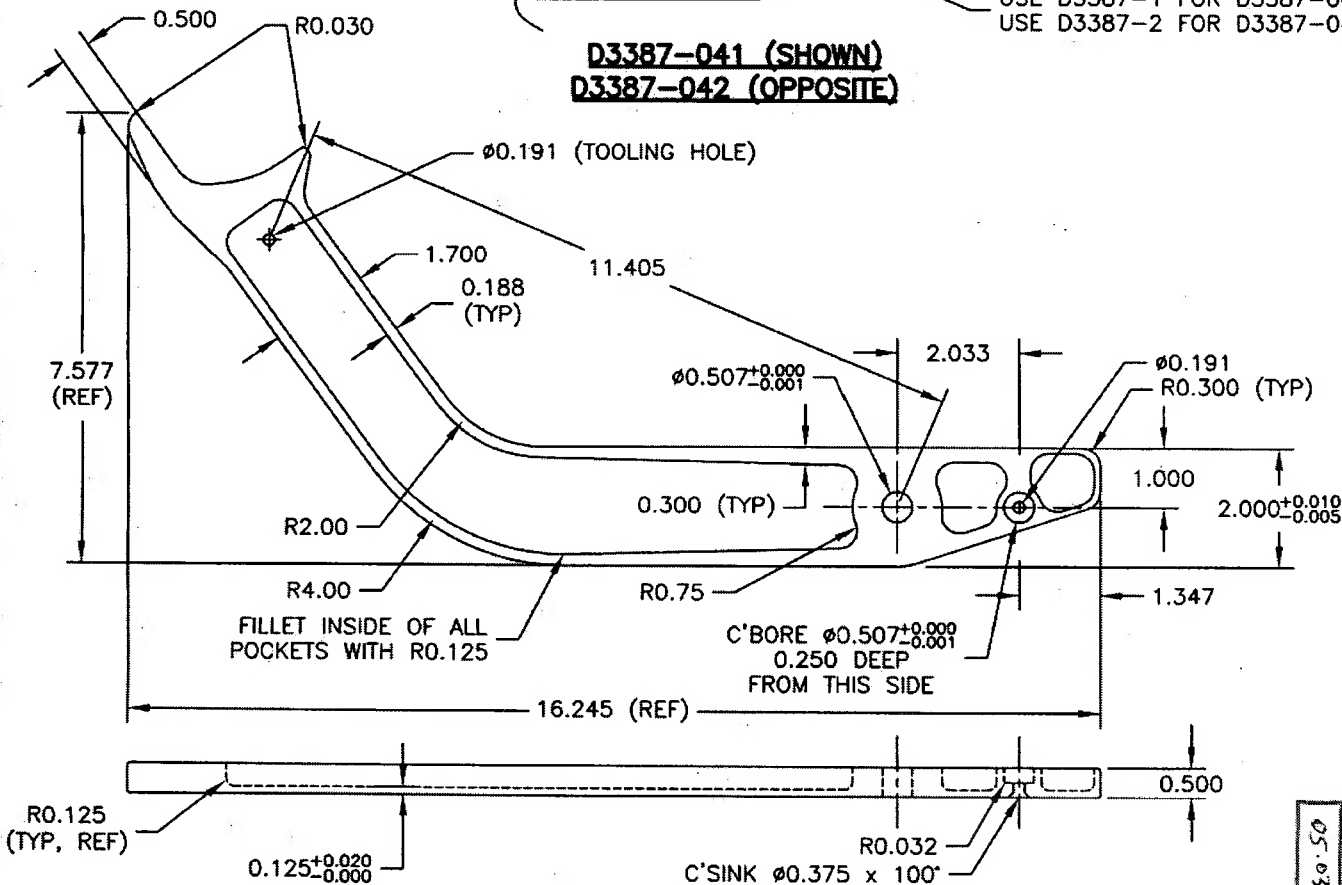
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3387	REV. A
DATE 05.01.18	TITLE ARM	SHEET 1 OF 1	SCALE 1:3
A	05.01.18	NEW ISSUE	

RELEASED

05.03.11



D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

MACHINE PER DRAWING FILE "D3387-A.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27288